

# Work Order ID 73846

Friday, September 16, 2011 12:46:27 PM



Page 1

Item ID: D2662-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH In 206

Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 10.00



Customer:

Reference:

*[Handwritten Signature]*

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2662

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

*BA 11/09/27*  
*29 11.9.28*

*10* *φ*

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Inspect part number and batch number are programmed correctly. ☐ Fixturing Inspection last completed *11/09/27* by *BA* ☐ Machine Step No 1 of Folio and inspect per attached Dimension Sheet ☐ Machine Step No 2 of Folio

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

*29 11.9.28*

*10* *φ*

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

*29 11.9.28*

*10* *φ*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73846

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Item ID:	D2662-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, LH In 206					
Start Date:	9/16/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	10/14/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00	SL	11-09-28					
QC Quality Control	Memo	0.00							
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00				10	10	11-9-29	
150 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat Powder Coating	Memo	0.00							

Memo  
 START TIME: 8:00  
 FINISH TIME: 8:30  
 OVEN TEMPERATURE:

M118434

32005

8:30

10X Ø M-11/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73846

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Item ID:	D2662-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, LH In 206					
Start Date:	9/16/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	10/14/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				10 covered	6	11/10/03	
170 	Identify as per dwg & Stock Location: <u>435</u>	0.00							
Packaging Packaging	Memo	0.00							11/10/3
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							11/10/5

mf  
11-10-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 73846

Parent Item: D2662-1

Parent Item Name: Saddle, LH In 206


Start Date: 9/16/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.06.22 Removed P/O for powder coat EC  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	49.0000	1	10			

Saddle Billet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	49	
64777	20	
66965	1	
69677	2	
✓70976	10	
72225	16	

10

B.A 11/09/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> 206 Saddle, Inboard, Left side		<b>Part Number:</b>	D2662-1
<b>Inspection Dwg:</b> D2662 Rev. D		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					Date
				1	2	3	4	5 By	
A	0.100	0.140	2G. 02	.113	.113	.113	.113	.113	
B	0.100	0.140		.137	.137	.137	.137	.137	
C	1.125	1.145		1.140	1.140	1.140	1.140	1.140	
D	0.615	0.685		0.685	.685	.685	.685	.685	
E	0.240	0.260		.245	.245	.245	.245	.245	
F	1.313	1.343		1.322	1.322	1.322	1.322	1.322	
G	0.210	0.230		.222	.222	.222	.222	.222	
H	0.100	0.180		0.135	.135	.135	.135	.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.580	1.580	1.580	1.580	1.580	
K	0.235	0.240		0.238	.238	.238	.238	.238	
L	0.100	0.120		0.110	.110	.110	.110	.110	
M	0.990	1.010		0.992	.992	.992	.992	.992	
N	0.510	0.515		0.514	.514	.514	.514	.514	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		0.315	.315	.315	.315	.315	
S	0.315	0.322		0.317	.317	.317	.317	.317	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		0.797	.797	.797	.797	.797	
W	0.540	0.560		0.550	.550	.550	.550	.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		0.258	.258	.258	.258	.258	
Z	0.912	0.932		0.923	.923	.923	.923	.923	
AA	0.490	0.510	"	.501	.501	.501	.501	.501	
AB	0.178	0.198	2G.	0.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>K.A.</u>	Audited by: <u>SL</u>
Date: <u>11/09/27</u>	Date: <u>11-09-28</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Inboard, Left side	Part Number:	D2662-1
Inspection Dwg: D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					Date
				16	17	18	19	10	
A	0.100	0.140	29.02	.113	.113	.113	.113	.113	
B	0.100	0.140		.131	.137	.137	.137	.137	
C	1.125	1.145		1.140	1.140	1.140	1.140	1.140	
D	0.615	0.685		.685	.685	.685	.685	.685	
E	0.240	0.260		.245	.245	.245	.245	.245	
F	1.313	1.343		1.322	1.322	1.322	1.322	1.322	
G	0.210	0.230		.222	.222	.222	.222	.222	
H	0.100	0.180		.135	.135	.135	.135	.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.580	1.580	1.580	1.580	1.580	
K	0.235	0.240		.238	.238	.238	.238	.238	
L	0.100	0.120		.110	.110	.110	.110	.110	
M	0.990	1.010		.992	.992	.992	.992	.992	
N	0.510	0.515		.514	.514	.514	.514	.514	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.315	.315	.315	.315	.315	
S	0.315	0.322		.317	.317	.317	.317	.317	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.797	.797	.797	.797	.797	
W	0.540	0.560		.550	.550	.550	.550	.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.258	.258	.258	.258	.258	
Z	0.912	0.932		.923	.923	.923	.923	.923	
AA	0.490	0.510	"	.501	.501	.501	.501	.501	
AB	0.178	0.198	26.	.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	RG
Date:	11.9.28

Audited by:	SL
Date:	11-09-28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format: Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



